

Work Order ID 66568

Tuesday, February 22, 2011 10:28:16 AM

Page 1

Item ID: D4151-1

Accept

Revision ID:

Item Name: Lower Hardpoint Plate

Start Date: 2/23/2011 Start Qty: 6.00

Required Date: 3/9/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: CNF Date: 11-02-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4151

C

0.00

0.00

0.00

0.00

100



Waterjet

FLOW CNC Waterjet

304 125

Memo

- Cut as per dwg D4151

Prog Rev: EDwg Rev: E

Deburr as required

B11-2-22

6

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

B11-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4151-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Lower Hardpoint Plate

Start Date: 2/23/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/11/02/22

(46)

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

8/11/02/22

11/2/22 83 (2)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/23

MF

11-02-22

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Picklist Print

Tuesday, February 22, 2011 10:28:13 AM

Page 1

Work Order ID: 66568



Parent Item: D4151-1



Parent Item Name: Lower Hardpoint Plate

Start Date: 2/23/2011



Required Date: 3/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
11.01.21 as per dwg revC DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	46.5800	0.0508	0.320842			
 													
304/316 0.125 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		46.58							
				116623		46.58							

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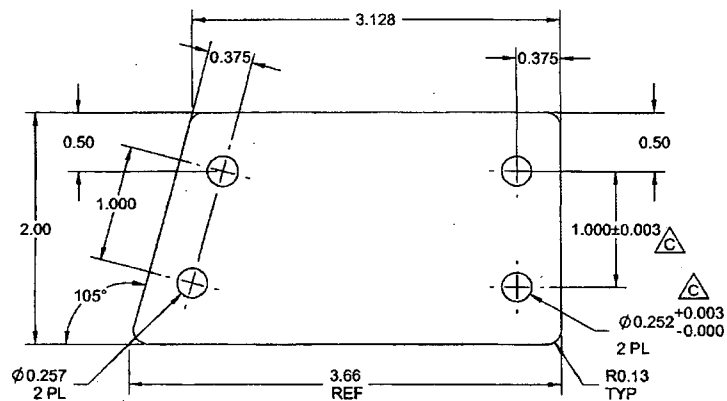
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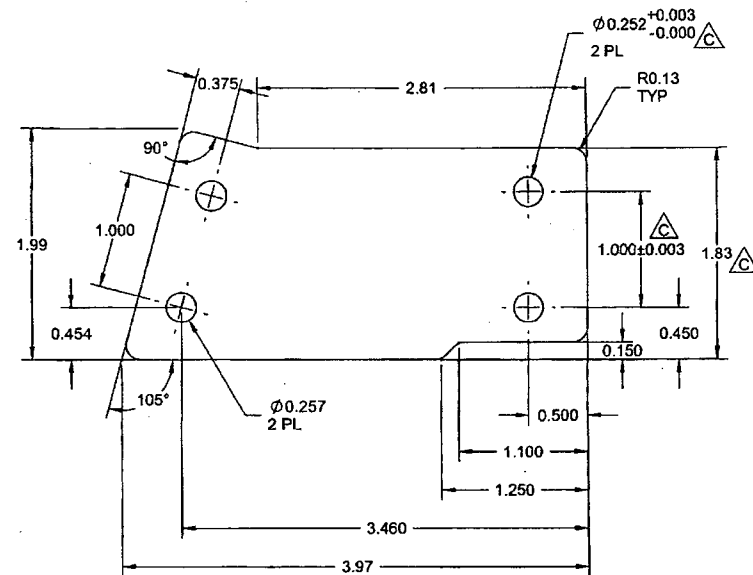
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0.125 REF
D4151-1 LOWER HARDPOINT PLATE



0.125 REF
D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
 - D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
R 2011-01-18
JMP

W/O:		WORK ORDER CHANGES					
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